

Date: Monday, 11/12/2007 11:46:09 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HI-STEP LEG ASSEMBLY		
Job Number	35624		Part Number	D3065041		
Estimate Number	10385		Drawing Number	D3065 REV B		
P.O. Number	:		Project Number	N/A		
This Issue	11/12/2007	S.O. No. :	Drawing Revision	:		
Prsht Rev.	NC		Material	:		
First Issue	11	Type : SMALL /MED FAB	Due Date	12/10/2007	Qty:	50
Previous Run	35622		Um:	Each		
Written By	:		100	u		
Checked & Approved By	:		100	u		
Comment	Est Rev:	C 02.11.01	Incorporated D3066-1 IPP KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D30651	Step Spacer		50
				mf
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)		
		Step Spacer		
		B 35614		
2.0	D30653	Step Spacer		50
				mf
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)		
		Step Spacer		
		B 3561-5		
3.0	D30655	Step Leg		100
				mf
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s)		
		Step Leg		
		B 35620		
4.0	D30657	Step Spacer		50
				mf
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)		
		Step Spacer		
		B 35616		
5.0	MS20470AD44	Rivet, Universal Head		1500
				mf
		Comment: Qty.: 30.0000 Each(s)/Unit Total : 900.0000 Each(s)		
		Rivet, Universal Head		
		Pick:		
	Qty	Part Number	Description	Batch
	30	MS20470AD4-4	Rivet	m106654
				mf
				08-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HI-STEP LEG ASSEMBLY
Job Number: 35624		Part Number: D3065041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3065 and Identify as D3065-041		mf 08-03-05 (50)
7.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		08/03/06 (X50)
8.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE.#1 Identify and Stock Location: <u>WTA</u>		KE 08.03.07 (50)
9.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		D 08/03/06 (50)
Job Completion 		2006/3/06 (150)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

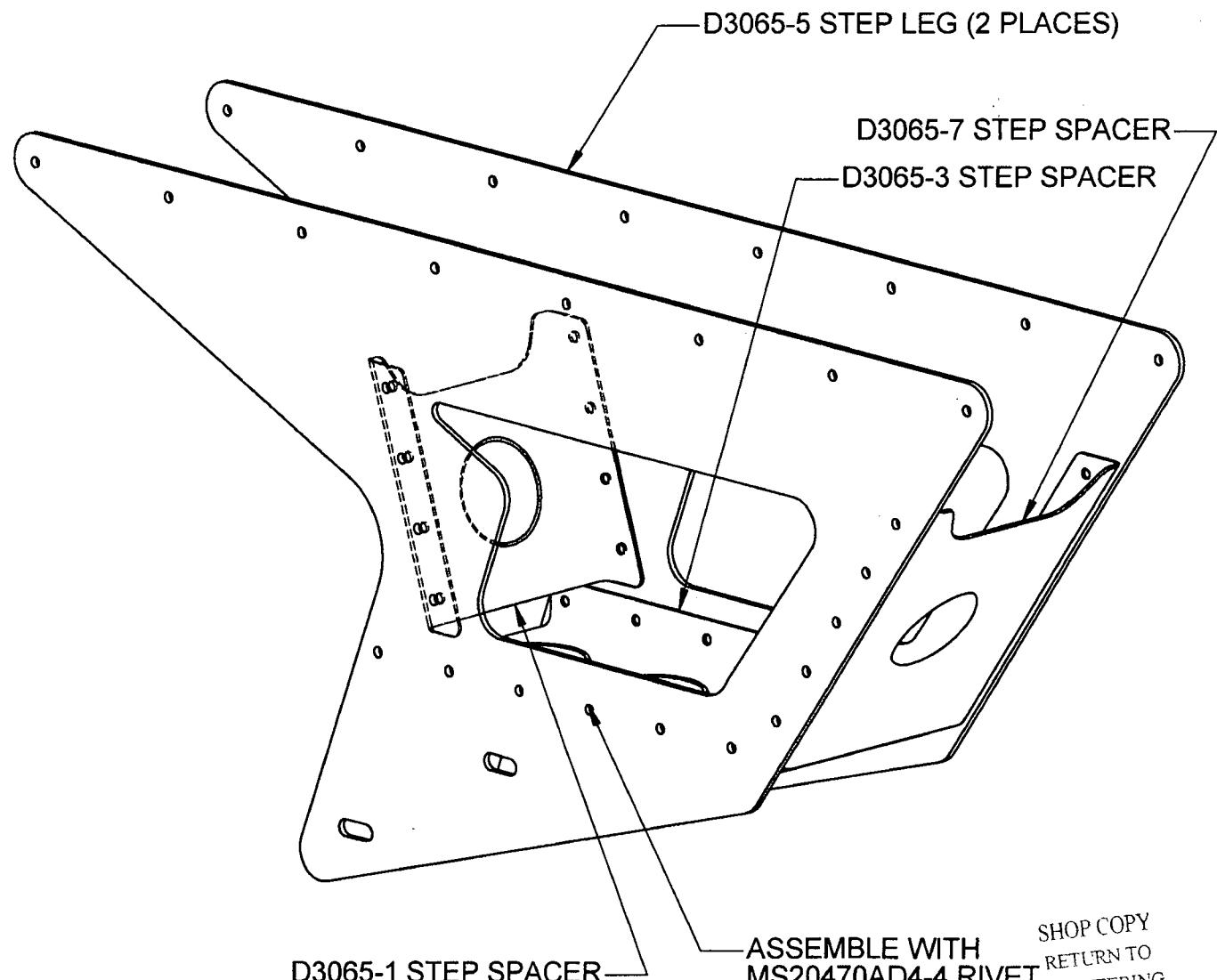
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3065	REV. B	SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE	1:2
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

RELEASED*06.06.20 *TH****D3065-041 STEP LEG ASSEMBLY**

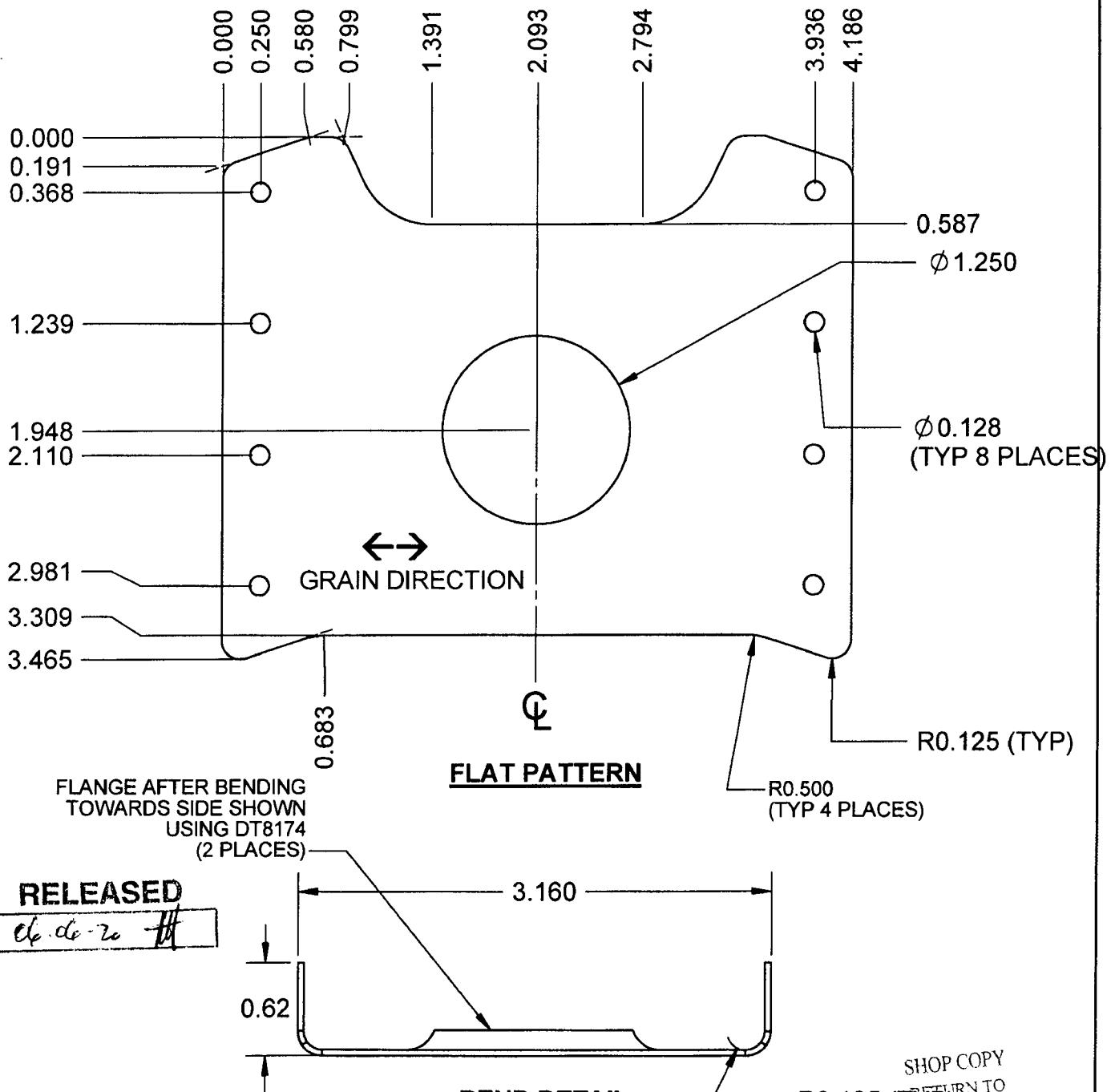
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. *35624*

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065
DATE	06.05.23	TITLE STEP LEG ASSEMBLY

REV. B
SHEET 2 OF 5
SCALE
1:1**D3065-1 STEP SPACER**

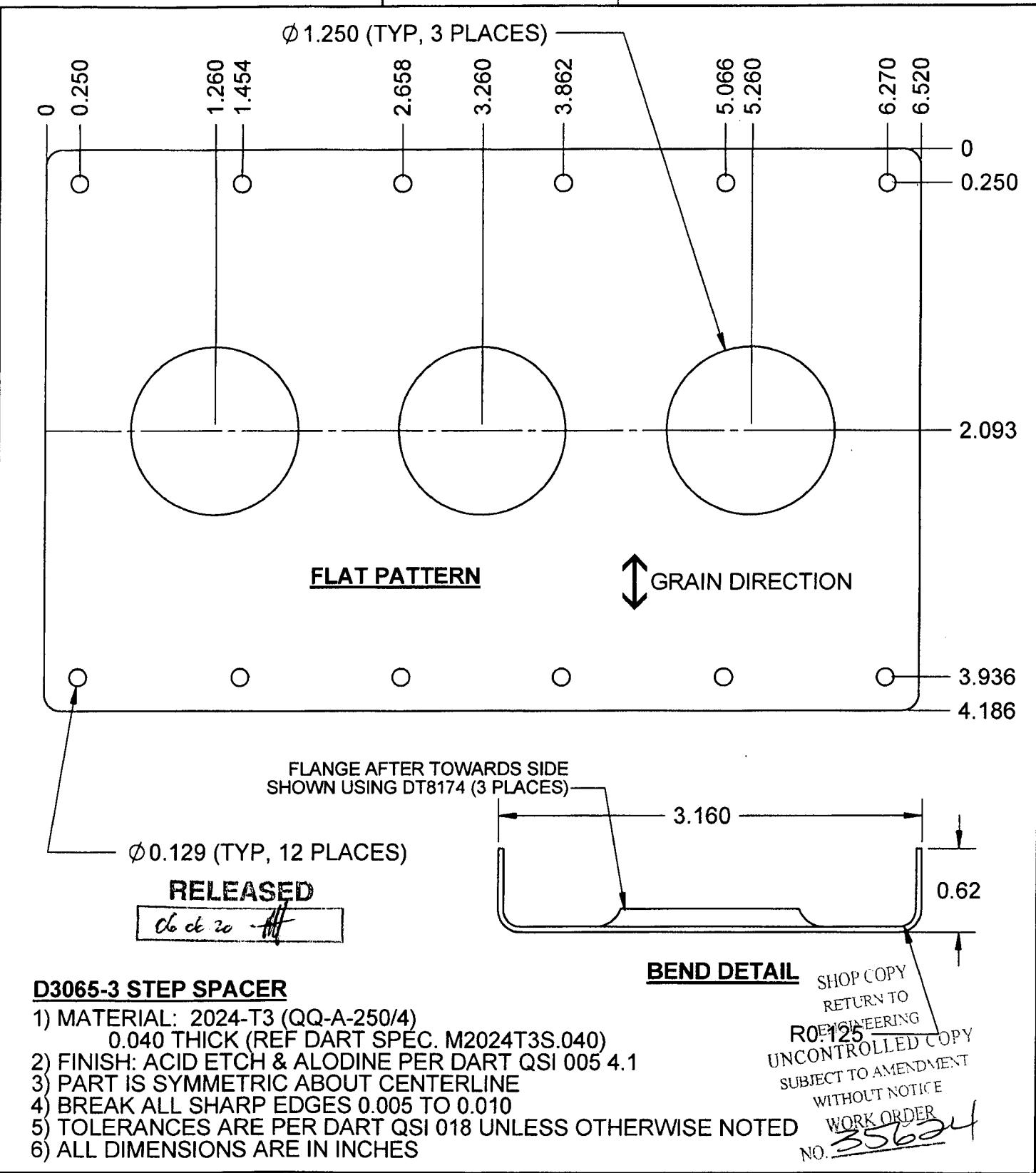
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

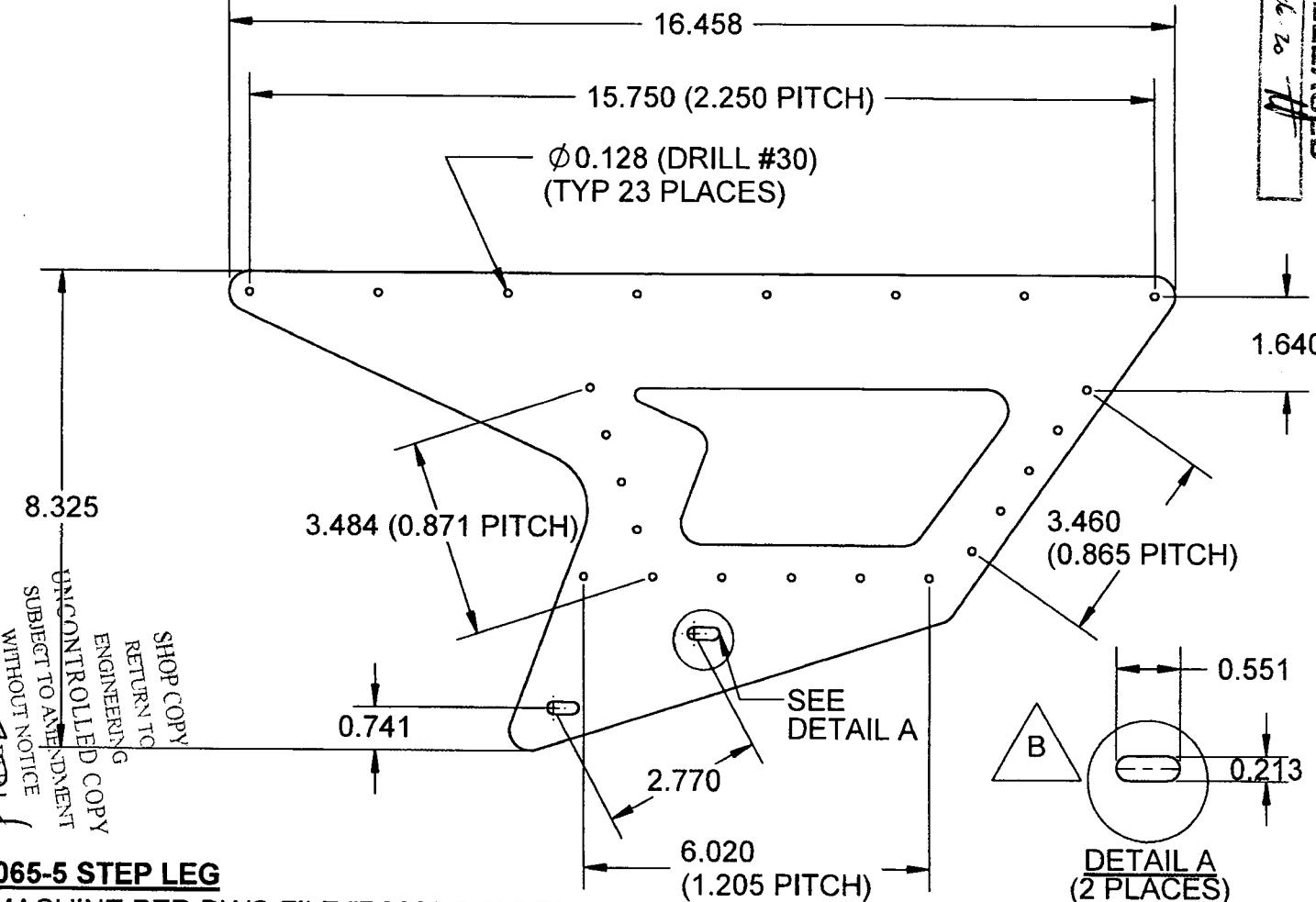


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DESIGN <i>19</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>JK</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5 SCALE 1:3

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D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

